

Date: Wednesday, 9/12/2007 12:13:22 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT PLATE
Job Number : 34599	
Estimate Number : 10316	
P.O. Number : <i>N/A</i>	Part Number : D2680041
This Issue : 9/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2680 REV B1
Prsht Rev. : <i>NC</i>	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 33061	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/10/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>140</i> Um: <i>Each</i>
Comment : Est: D 04.10.01 Added Steps 2-4, 7-8 KJ/JLM Est Rev: E Now on WaterJet 06-10-12 JLM est rev F QC5 after c'sink 07.07.05 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.0138 sf(s)/Unit Total : 0.6878 sf(s)-  
 1010/1025/A21/6aA SHEET .063" thk  
 Batch: *m101034* *HB 07-09-17*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2680  
 Dwg Rev: *B1*  
 Prog Rev: *B1*

*HB 07-09-17*

2-Debur if necessary

*SAD 07/09/22*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Debur

2-C'sink as per Dwg D2680

*SAD 07-09-23**SAD 07-09-01**139**140*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/01/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/12	2.0	20 parts were found during water getting to have a small cutout on the side. RL Parts were too close to		Parts are acceptable	 07/01/12	 07/01/12	 07/01/12	 07/01/12
		together during water getting and operator error						
07-10-01	5.0	One part scrap during the C'sink, Slip and didn't do the C'sink correctly		Scrap, destroy	 07-10-01	 07-11-01	 05/10/12	 12/11/01

NOTE: Date & initial all entries

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Drawing Name: NUT PLATE

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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



QSPOR



counted

Comment: INSPECT WORK TO CURRENT STEP

7/11/02

139

7.0

POWDER COATING

POWDER COATING



M105914



139X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.k

07/11/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd

07/11/06

139

9.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

278

Qty	Part Number	Description	Batch
2	MS20426AD3-3	Rivet	

M1563

AS

07/11/06

10.0

MS21069L4

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

139

Qty	Part Number	Description	Batch
1	MS21069L4	Nut Plate	

M18536

AS

07/11/06

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D2680

07/11/08

139

12.0

QC5

INSPECT WORK TO CURRENT STEP



QSPOR



counted

Comment: INSPECT WORK TO CURRENT STEP

07/11/08

139

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57/140

AS 07/11/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/11/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Job Number: 34599

Part Number: D2680041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



139

Comment: FINAL INSPECTION/W/O RELEASE

DOTM/12

Job Completion



le OF-LL-R

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

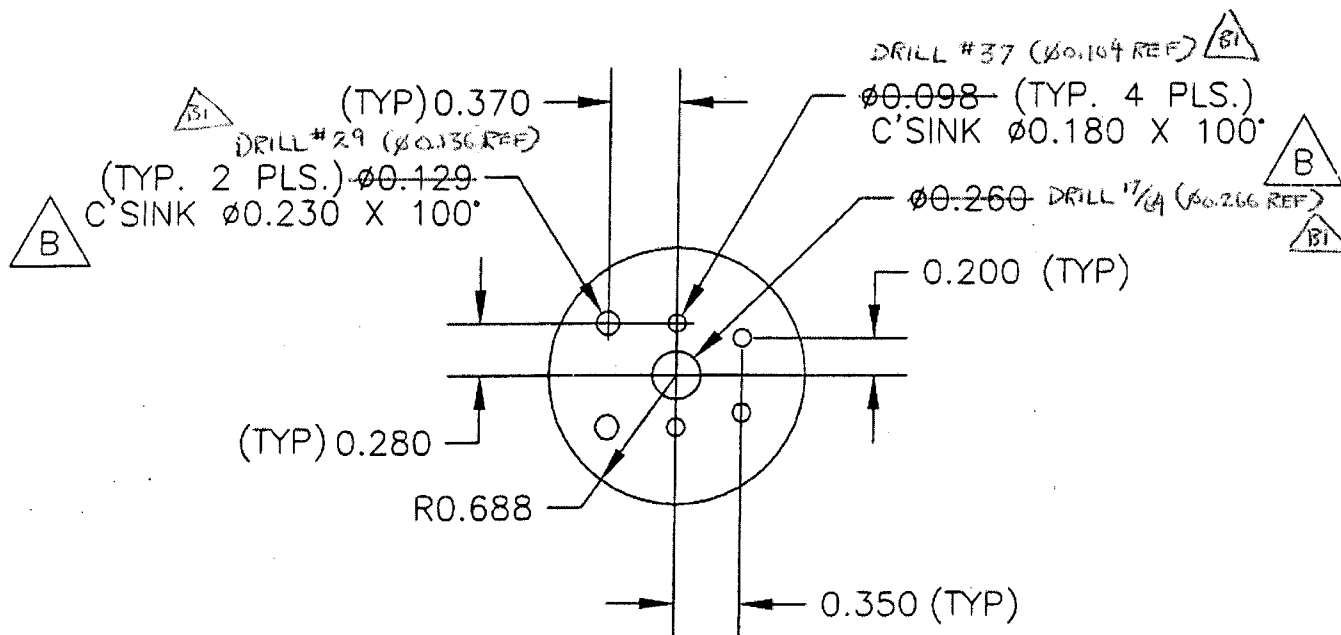
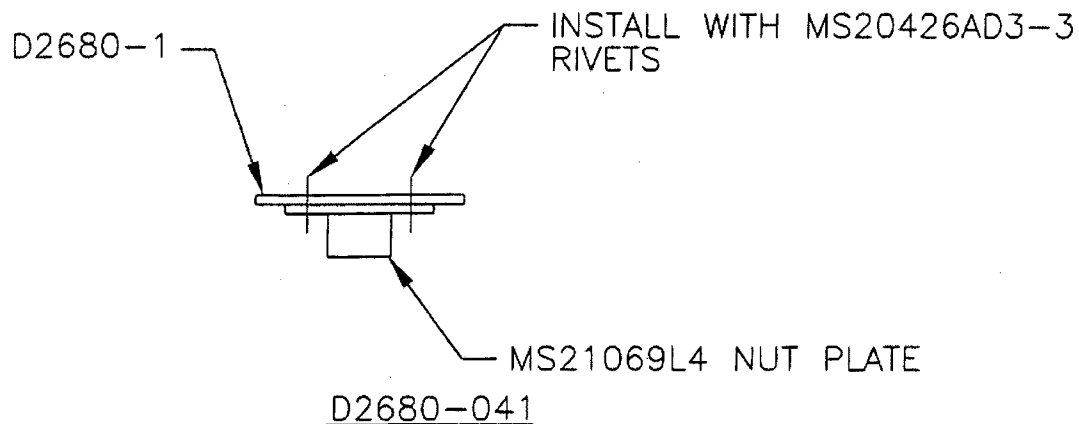
NOTE: Date & initial all entries





DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE		SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	CP-# 04.11.04	CHANGE HOLES & FINISH	

RELEASED  
98.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

$\triangle B1$  POWDER COAT WHITE (4.755.2) PER DART QSI 605 4.3  
D2680-1

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34599